

Date: Tuesday, 9/25/2007 10:14:20 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE, INBOARD, LS, 206
Job Number	34859	Part Number	D26661
Estimate Number	10820	Drawing Number	D2666 REV. D
P.O. Number		Project Number	N/A
This Issue	9/25/2007	Drawing Revision	D
Prsht Rev.	NC	Material	
First Issue	/ /	Due Date	10/10/2007
Previous Run	33797	Qty:	12
Written By		Um:	Each
Checked & Approved By	<i>DP 07/09/05</i>		
Comment	Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC		
	Est Rev:D As per Rev D 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6101001	7075-T7351 2X6X6.25	
	Comment: Qty: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) 7075-T7351 2X6X6.25 Issue material from stock: Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length	Batch No: <i>B24872</i>	<i>DP 08/02/01</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1-Inspect part number and batch number are programmed correctly. 2-Fixturing Inspection last completed on <i>3/1/05</i> by <i>DP</i>		(13)
	3-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 8-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 9- Deburr		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
	Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet		(13)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2666-1 PAR #: N/A Fault Category: Prod / machine fails NCR Yes No DQA: D QA: N/C Closed: H Date: 08/02/08

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/04	2.0	The billet was not squared in prog. #26661 LC. origin was wrong	CP 08.02.04 pu	Moved origine Scrap and Destroy QH (x) B# 34859	DSP 08/02/04	08/02/04	CP 08.02.05 pu 051042	08/02/05
08/02/04	2.0	The billet was not squared in prog. #26661 LC. origin was wrong	CP 08.02.05 pu	Moved origine Part is acceptable	DSP 08/02/04	08/02/05	CP 08.02.05 pu 051042	08/02/05
08/02/04	2.0	5 first parts; the 0.316 ϕ holes are over tol. by 0.002". 1 part have groove from chamfer tool on the Skid Bolt island	CP 08.02.09 pu 051042	Changed the drill; PARTS ACCEPTABLE	DSP 08/02/04	08/02/05	CP 08.02.09 pu 051042	08/02/05

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 34859

Part Number: D26661

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

(initials) 08-02-06 (B)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

M.F.

08/02/06

7.0 POWDER COATING POWDER COATING



M106379

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Fx 08/02/07 (B)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M.F.

08/02/07

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST426*

AS 08/02/07 (B)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1D 08/02/08

Job Completion



mm 2008/2/07 (B)

U

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	34859
Description: 206 Saddle, Inboard, Left side				Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.135	0.137	0.1365	0.138		
B	0.100	0.140		.130	0.1293	0.130	0.127		
C	2.470	2.510		2.490	2.493	2.495	2.492		
D	0.100	0.180		.144	0.144	0.142	0.144		
E	0.210	0.230		.221	0.223	0.222	0.222		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.240	0.260		.251	0.250	0.249	0.248		
H	0.615	0.685		.649	0.675	0.675	0.680		
I	1.125	1.145		1.138	1.138	1.138	1.142		
J	0.990	1.010		1.009	1.007	1.008	1.0075		
K	0.235	0.240		0.237	0.239	0.238	0.237		
L	0.510	0.515		0.510	0.510	0.510	0.511		
M	0.100	0.120		0.109	0.108	0.105	0.105		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.25	1.25	1.25	1.25		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		0.500	0.500	0.500	0.500		
S	0.313	0.318		0.315	0.315	0.315	0.315		
T	2.495	2.505		2.501	2.500	2.500	2.500		
U	1.357	1.367		1.365	1.360	1.360	1.361		
V	0.315	0.322		0.324	0.324	0.324	0.324		
W	0.540	0.560		0.550	0.545	0.543	0.554		
X	1.674	1.684		1.680	1.678	1.678	1.678		
Y	0.257	0.262		.258	0.259	0.2585	0.259		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	DJP	Audited by:	
Date:	08/02/02	Date:	08.02.02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	34859
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		0.138	0.138	0.138	0.138		
B	0.100	0.140		0.127	0.126	0.1265	0.127		
C	2.470	2.510		2.493	2.494	2.494	2.494		
D	0.100	0.180		0.145	0.145	0.145	0.145		
E	0.210	0.230		0.221	0.221	0.221	0.221		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.240	0.260		0.248	0.248	0.248	0.248		
H	0.615	0.685		0.680	0.680	0.680	0.680		
I	1.125	1.145		1.145	1.145	1.145	1.145		
J	0.990	1.010		1.0075	1.0075	1.008	1.0075		
K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.510	0.515		0.511	0.511	0.511	0.511		
M	0.100	0.120		0.103	0.105	0.105	0.105		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		0.500	0.500	0.500	0.500		
S	0.313	0.318		0.315	0.315	0.315	0.315		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.361	1.361	1.361	1.3615		
V	0.315	0.322		0.324	0.320	0.320	0.320		
W	0.540	0.560		0.555	0.555	0.555	0.555		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									

Accept/Reject

Measured by:	DJP	Audited by:	
Date:	08/02/03	Date:	08.02.06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD				Work Order:	34859
Description: 206 Saddle, Inboard, Left side				Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.100	0.140	.138	0.138	0.138	0.138	0.138		
B	0.100	0.140	.126	0.126	0.126	0.126	0.126		
C	2.470	2.510	2.500	2.494	2.494	2.494	2.494		
D	0.100	0.180	.140	0.140	0.140	0.140	0.140		
E	0.210	0.230	.221	0.221	0.221	0.221	0.222		
F	1.313	1.343	1.325	1.325	1.325	1.325	1.325		
G	0.240	0.260	.248	0.248	0.253	0.2543	0.254		
H	0.615	0.685	.690	0.680	0.670	0.672	0.672		
I	1.125	1.145	1.145	1.143	1.141	1.143	1.143		
J	0.990	1.010	1.008	1.008	1.008	1.008	1.008		
K	0.235	0.240	.237	0.237	0.2365	0.237	0.237		
L	0.510	0.515	.511	0.511	0.511	0.511	0.511		
M	0.100	0.120	.105	0.105	0.105	0.105	0.105		
N	1.565	1.585	1.575	1.575	1.575	1.575	1.575		
O	5.990	6.010	6.001	6.001	6.001	6.001	6.001		
P	1.245	1.255	1.250	1.25	1.260	1.25	1.25		
Q	2.495	2.505	2.500	2.500	2.500	2.500	2.500		
R	0.490	0.510	.500	0.500	0.500	0.500	0.500		
S	0.313	0.318	.315	.315	0.315	.315	.315		
T	2.495	2.505	2.500	2.5	2.500	2.500	2.500		
U	1.357	1.367	1.361	1.361	1.361	1.361	1.361		
V	0.315	0.322	.320	.320	0.320	.320	.320		
W	0.540	0.560	.555	0.555	0.553	0.554	0.554		
X	1.674	1.684	1.674	1.678	1.678	1.678	1.678		
Y	0.257	0.262	.259	0.259	0.259	0.259	0.259		
Z	0.178	0.198	.185	.188	0.188	.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	DS/P	Audited by:	
Date:	08/02/04	Date:	08/02/04

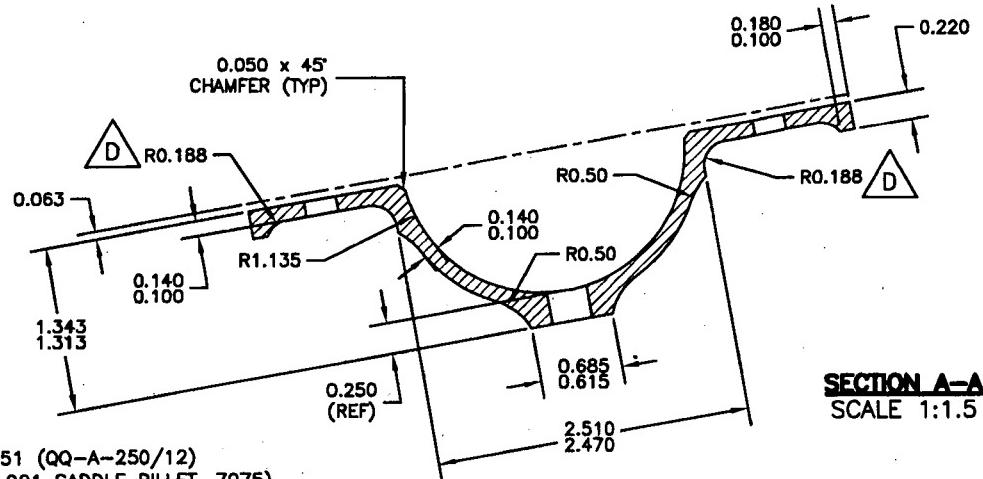
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN <i>#</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD INSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

RELEASED

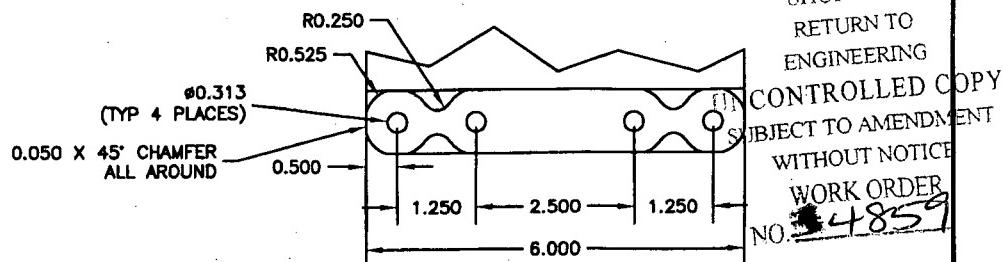
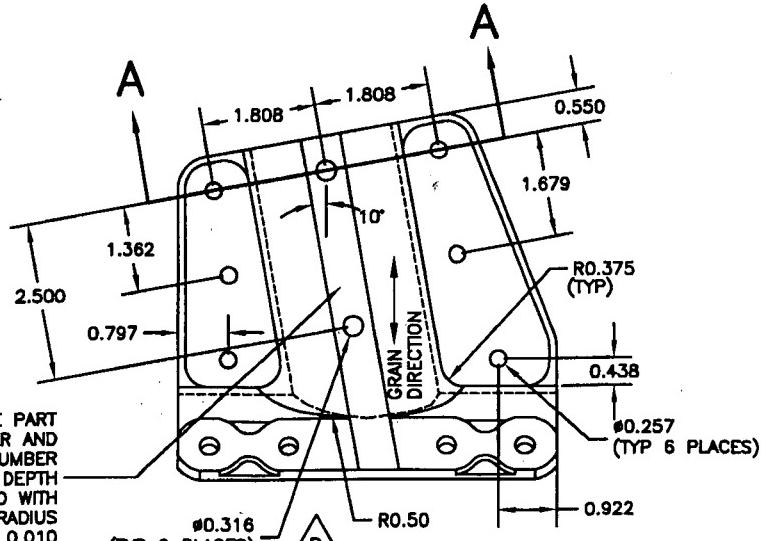
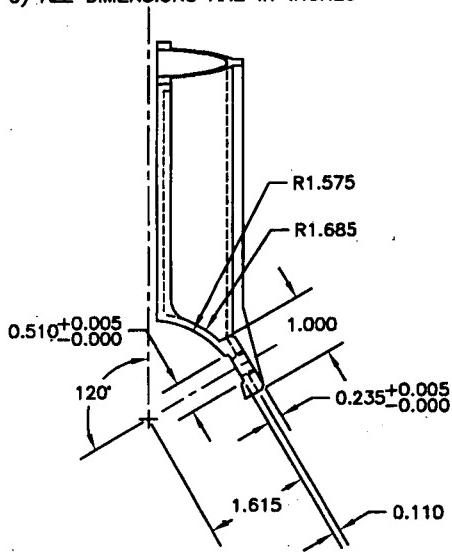
07.02.12 87



SECTION A-A
SCALE 1:1.5

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
 - 6) ALL DIMENSIONS ARE IN INCHES



D2686-1 SADDLE FWD INSIDE HIGH

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
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